

Date: Thursday, 2/22/2007 3:16:24 PM
 User: Kim Johnston

Process Sheet

38.1

30"

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 30866		
Estimate Number	: 12543		
P.O. Number	: N/A	Part Number	: D35381
This Issue	: 2/22/2007	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Number	: D3538 REV.A
First Issue	: N/A	Project Number	: 10254N/A
Previous Run	: 30635	Drawing Revision	: A
Written By	: <i>[Signature]</i>	Material	: N/A
Checked & Approved By	: <i>[Signature]</i> 07.02.23	Due Date	: 3/21/2007
Comment	: Est Rev:A New Issue 06-10.03 EC	Qty:	20
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"	
		Comment: Qty.: 0.1995 f(s)/Unit Total : 3.9900 f(s) 6061_T6 Bar 1.250" x 1.250 Batch: <i>1103629</i>	<i>SA 07.03.12</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 1.500" long	<i>SD 07.03.12</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: 1-Machine as per Folio FA651 and Dwg D3538	
4.0	QC2	2-Deburr INSPECT PARTS AS THEY COME OFF MACHINE	<i>QH 07/03/14 (20)</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>QH 07/03/14 (20)</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>SP 07/03/14 (20)</i>
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>M.F. 07/03/15 (20)</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/119
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:16:24 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 30866

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Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



M103706



(QJX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.f

07/03/15

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/15 (20) 10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/15 (20)

10

(20)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



U 07/03/16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

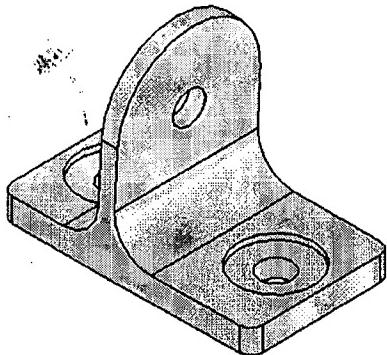
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

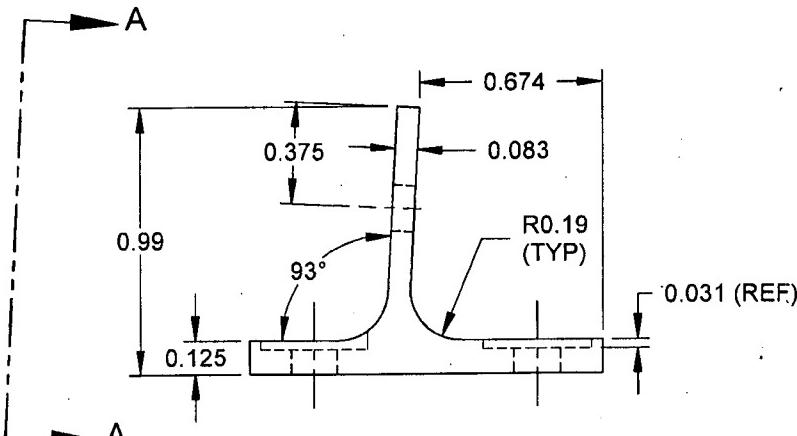
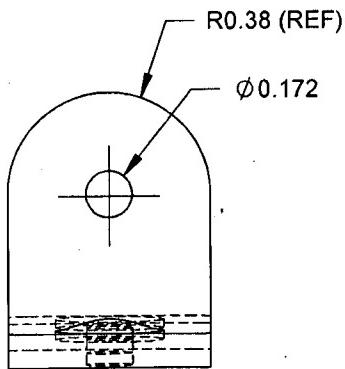
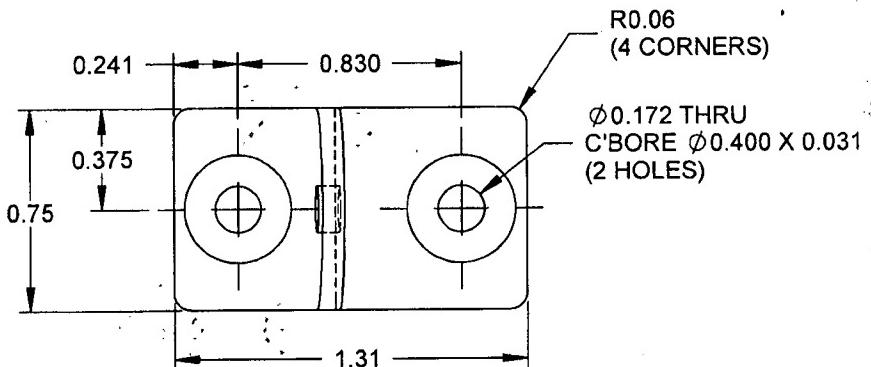
NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	



RELEASED
06.10.13 TH

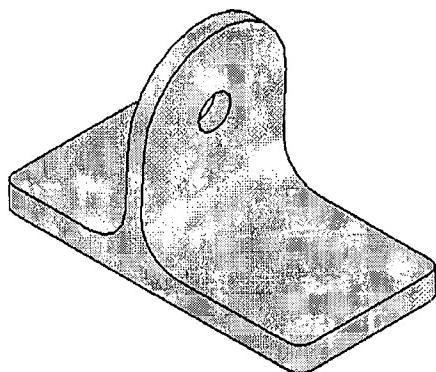
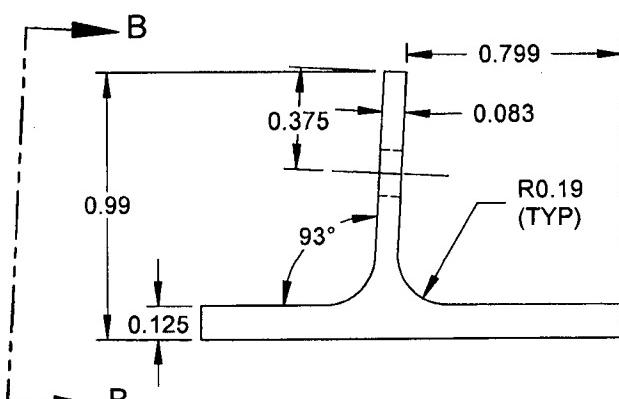
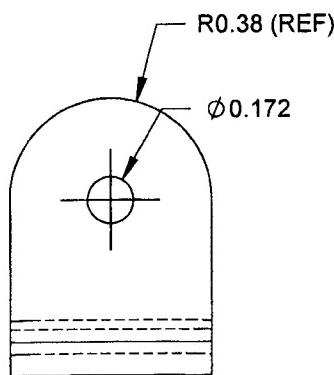
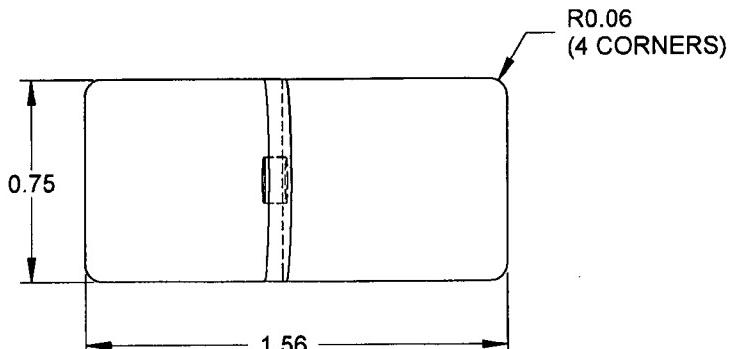

AUXILIARY VIEW A
D3538-1 HINGE BRACKET
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30866*

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13	TITLE HINGE BRACKET	SCALE 1:1	

**RELEASED**
06.10.13**AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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WITHOUT NOTICE
WORK ORDER
NO. *30866*

DART AEROSPACE LTD	Work Order:	30866
Description: HINGE BRACKET	Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Measured by:	<i>Amber</i>	Audited by:	<i>JF</i>	Prototype Approval:	<i>N/A</i>
Date:	<i>07/03/14</i>	Date:	<i>07/03/14</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	